

We claim:

1. A process for the coating of a wooden, wood-like and/or cellulose-containing substrate comprising the steps of:
- 5 a) applying a press coating to the substrate;
- b) applying heat and pressure to the coated substrate to cure the press coating and to obtain a substrate with a smooth coating film, with the pressure being such that the substrate is not substantially compressed;
- 10 c) applying a top coat to the substrate after the curing of the press coating; and
- d) curing said top coat.
2. The process according to claim 1, wherein in an additional step before the top coat is applied, a primer coating is applied and cured.
- 15 3. The process according to claim 1, wherein all process steps are performed on a single production line.
4. The process according to claim 1, wherein the top coat is a radiation curable top coat and the radiation curable top coat is cured using UV radiation.
- 20 5. The process according to claim 1, wherein before the top coat is applied, a printing is applied on the substrate and the top coat is applied on top of said printing.
- 25 6. The process according to claim 1, wherein the press coat is a aqueous colloidal dispersion comprising particles of a polymer of an ethylenically unsaturated monomer and 40 - 60 wt.%, based on the total weight, of the emulsion solids of filler and/or pigment.

7. A wooden, wood-like and/or cellulose-containing substrate coated with a press coat and at least one radiation curable coating layer comprising unreacted double bonds wherein the amount of unreacted double bonds in the substrate after curing of the radiation curable coating layer as measured by IR Chromatography is less than 15% of the total amount of double bonds present in the uncured coating composition.
8. The substrate according to claim 7, wherein the amount of unreacted double bonds in the substrate as measured by IR Chromatography is less than 10% of the total amount of double bonds present in the uncured coating composition.